

Date: Thursday, 31/07/2008 12:17:57 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 40846	
Estimate Number : 10277	
P.O. Number :	Part Number : D2565105
This Issue : 31/07/2008 S.O. No. :	Drawing Number : D2565 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : E
Previous Run : 38029	Material :
Written By :	Due Date : 07/08/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD</u> 08.8.01	
Comment : Est: F02.04.16 Added dwg Rev.C1 NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.7666 f(s)/Unit Total: 17.6663 f(s)

304 RD TUBE .750 X.49W

Punch 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall to length as per Dwg D2565 using DT 8313

Batch M108846  
 (M304TR0750W049)

SB 08/08/27

(10)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Punch as per Dwg D2565 using DT 8313

SB 08/08/27

(10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill hole open to .316 Ø as per Dwg D2565 (one end only)

Deburr

08/09/04 10 km

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/09/04 10

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

7:45

OVEN TEMPERATURE:

400°

FINISH TIME:

8:15

FL 08/09/05

(Ph)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-105 PAR #: N/A Fault Category: Red Finishing NCR: Yes No DQA: D Date: 08/08/10  
 QA: N/C Closed: D Date: 08/09/11

NCR: 40846		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/8	5.0	2 struts were found to have markings on them from the material.	<i>[Signature]</i>	Scuff with 320 grit sand paper. and clean with Red scratch Brite and Acetone.	FL (2) 08/09/08	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
		R.C. Struts were not <del>being</del> cleaned enough.	<i>[Signature]</i>	Re Powder coat as per QS2005.	FL 08/09/08 (2)	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40846

Part Number: D2565105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(108)

Comment: INSPECT POWDER COAT

*M-f*

08/09/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 270

*8/09/09*

*SP*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/10 *ff*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-09-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

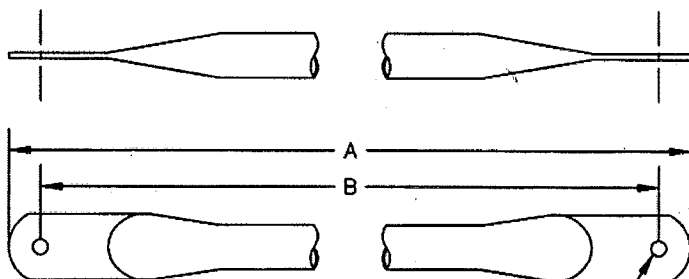
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 40846

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